

Date: Friday, 9/14/2007 2:00:49 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: LUG	
Job Number	: 34671A				
Estimate Number	: 10839				
P.O. Number	: N/A		Part Number	: D22491	
This Issue	: 9/14/2007 S.O. No. : N/A		Drawing Number	: D2249 REV. E	
Prsht Rev.	: NC		Project Number	: N/A	
First Issue	: N/A		Drawing Revision	: E	
Previous Run	: 34115		Material	: N/A	
Written By			Due Date	: 10/20/2007 Qty: 10 Um: Each	
Checked & Approved By					
Comment	: Est: D 05-02-04 Added Step 9 KJ/RF Est Rev:E Now on Waterjet 07-03-08 JLM				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304S16GA	304/316 .063 Sheet
Comment: Qty.: 0.0903 sf(s)/Unit Total : 0.9030 sf(s) 304/316 .063 Sheet Batch: m10S130 1B 07-09-19		
2.0	WATER JET	FLOW WATER JET
Comment: FLOW WATER JET 1-Cut as per Dwg D2249 Dwg Rev: E 1B 07-09-19 Prog Rev: E		
2-Deburr if necessary SAD 07/09/20 30		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
1B 07-09-19 Comment: INSPECT PARTS AS THEY COME OFF MACHINE		
4.0	QC8	SECOND CHECK
Comment: SECOND CHECK 1B 07-09-19 (30)		
5.0	PACKAGING 1	PACKAGING RESOURCE #1
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: 5722		
1B 07-09-19 (30)		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 01/09/21
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 9/14/2007 2:00:49 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG

Job Number: 34671A

Part Number: D22491

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0

QC21

INSPECT PARTS AS THEY COME OFF MACHINE



Final w/o inspection



(30)

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

D9/14/07

Job Completion



U 9/14/21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	34671A
Description: Lug	Part Number:	D2249-1
Inspection Dwg: D2249	Rev: E	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

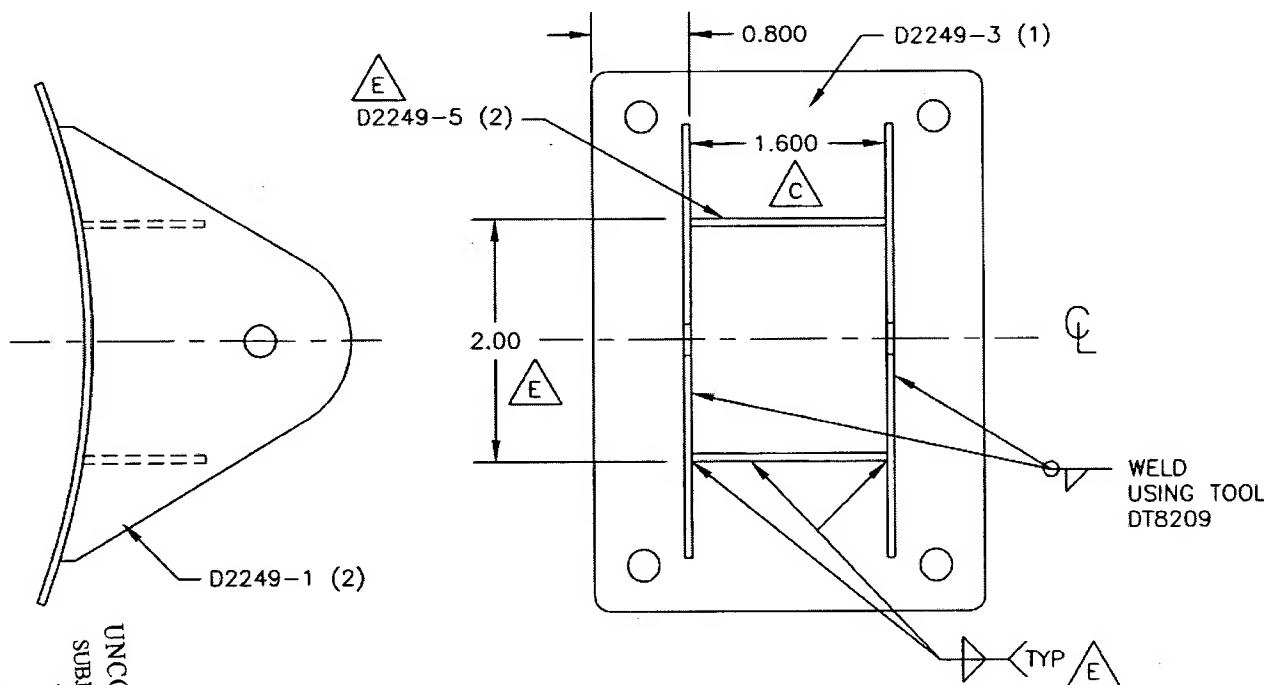
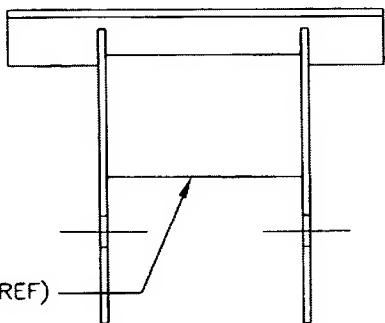
X First Article Prototype

Measured by:	JB	Audited by:	CR	Prototype Approval:	N/A
Date:	07-09-19	Date:	07/09/21	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.03.23	New Issue	KJ/JLM 	

DART**RELEASED**99.10.12
KE

DESIGN KE	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED KE	APPROVED W	DRAWING NO. D2249
DATE 99.09.20	TITLE FITTING	REV. E SHEET 1 OF 4 SCALE NTS
A 94.06.20	NEW ISSUE	
B 95.11.30	DIMENSION CHANGE	
C 95.12.14		
D 98.04.30	Ø0.261 WAS Ø0.257 (TSR A179) REMOVED DUPLICATE DIMENSIONS	
E 99.09.20	ADDED GUSSET	

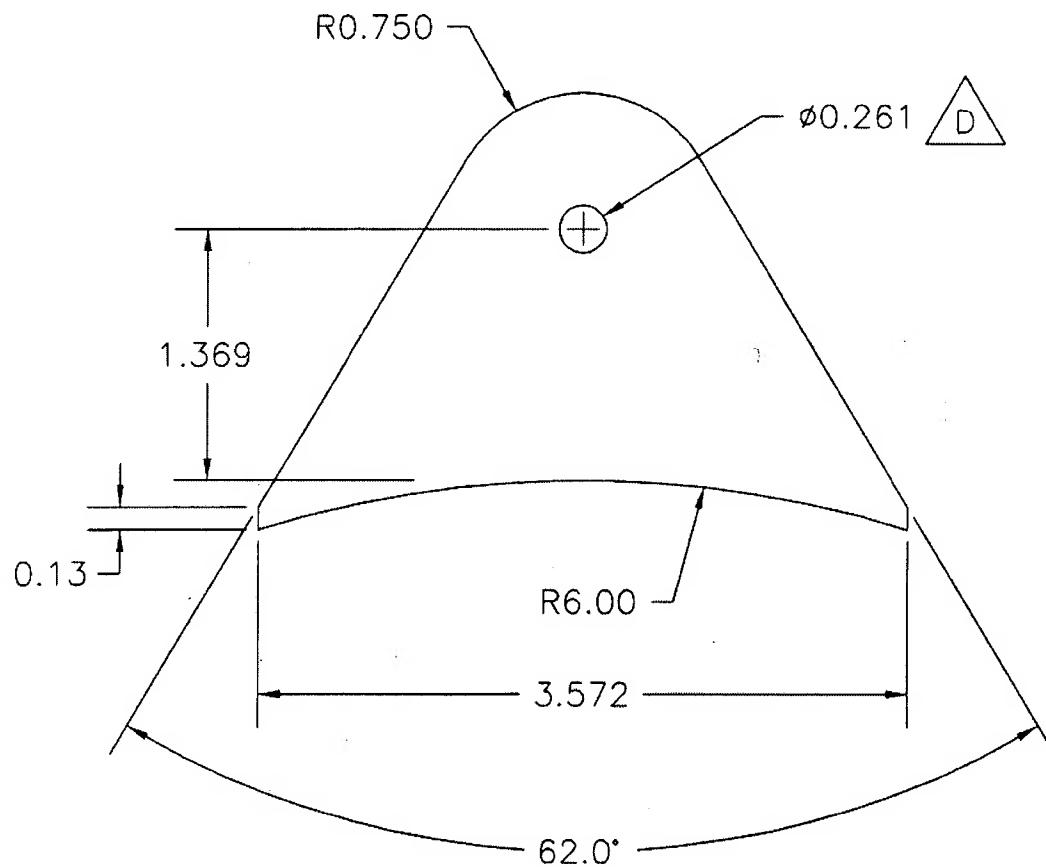
D2249-041 ASSEMBLY

MATERIAL: AISI 304/316 SS, 0.063 THICK
WELD PER DART QSI 004
FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
ALL DIMENSIONS ARE IN INCHES
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE SPECIFIED

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TO

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CHECKED <i>KE</i>	APPROVED <i>RF</i>	DRAWING NO. D2249
DATE 99.09.20	TITLE FITTING	REV. E SHEET 2 OF 4 SCALE 1:1

RELEASED
99.10.12 KED2249-1 LUG

MATERIAL: AISI 304/316 SS 0.063 THICK
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CHECKED <i>KE</i>	APPROVED <i>MM</i>	DRAWING NO. D2249	REV. E SHEET 3 OF 4
DATE 99.09.20		TITLE FITTING	SCALE 1:1

RELEASED
(99.10.12 KE)**Ø0.261 (TYP) D R0.125 (TYP)**

4.44

3.690



R6.0

2.400

0.375 (TYP)

3.20

0.400 (TYP)

FLAT PATTERNBEND DETAILD2249-3 BASE PLATE

MATERIAL: AISI 304/316 SS 0.063 THICK

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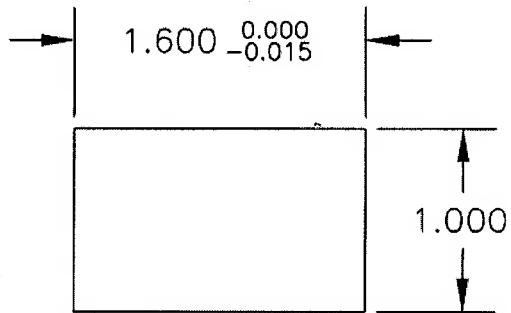
DART

COPY ISSUED

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CHECKED <i>KE</i>	APPROVED <i>SP</i>	DRAWING NO. D2249	REV. E SHEET 4 OF 4
DATE 99.09.20		TITLE FITTING	SCALE 1:1

RELEASED

99.10.12 KE

D2249-5 GUSSET

MATERIAL: AISI 304/316 SS 0.063 THICK

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